

Work Order ID 113011

February-11-14 3:18:37 PM

113011

Page 1

Item ID: D3562-042

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Step Weldment

Stop

NS2

Start Date: 2/21/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/21/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLS

Date: 14-02-12

Tooling:

Date:

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3562	F								

100

100

Large Fab

0.00

1 0 AK
14-03-11

Large Fab

Large Fab

Memo 1-Cut D2622 extrusion as per Dwg D3562

2-Deburr and bevel ends for welding

3 - TRANSFER HOLES FROM ARMS

110

110

QC6- Inspect dimensions to drawing

0.00

1 d DAS
19
14-03-11

QC

Quality Control

120

120

Chemical Conversion Coat per QSI005 4.1

0.00

1 26/4/3/11

HandFinish

Hand Finishing

Memo

0.00

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS							
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General									
	<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Pressure/Forced					
	<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Set-up					
	<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Temperature/Cure					
	<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Weld					
	<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Wrong Stock Pulled					
	<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong	<input type="checkbox"/> Other					
	<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge						
	<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread							
	<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set							
	<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration							
	<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence							

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Page 2

Item ID: D3562-042

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Step Weldment

Stop

NS2

Start Date: 2/21/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/21/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID
130

Operation
Description
QC7-Inspect Chemical Conversion Coat

Set Up/
Run Hours
0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC

Quality Control

DAS

19

89

14-03-18

140

Small Fab

0.00

140

Small Fab

Memo

0.00

Small Fab

1- Transfer drill Rivet holes as per dwg D3562.

1 0

Ae
14-03-18

2-Touch-up rivet holes with alodine as per dwg d3562

3-Rivet legs using Scotch-Weld as per dwg D3562.

*****Ensure to wipe off any excess magnobond *****

A/R Scotch-Weld DP460

Batch: M126005 EXP DATE: 14-05-01

DQA:

Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: _____

Work Order update only

Work Order: _____	DISPOSITION		
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Water Jet <input type="checkbox"/>
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>
		Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>

AGAINST DEPARTMENT/PROCESS

Engineering <input type="checkbox"/>
Quality <input type="checkbox"/>
Other <input type="checkbox"/>

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear		General									
		Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>					
		Centre Not Concentric <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>					
		Cracks <input type="checkbox"/>	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>					
		Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>					
		Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>					
		Crushing <input type="checkbox"/>	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>						
		Heat Treat <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Other <input type="checkbox"/>					
		Inspection Strip in Tube <input type="checkbox"/>	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>							
		Marks/Chatter <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>							
		Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>							
		Wave/Twist in Tube <input type="checkbox"/>	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>							

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Page 3

Item ID: D3562-042

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Step Weldment

Stop

NS2

Start Date: 2/21/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/21/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

150 QC Quality Control 1 8 DAS 19 14-03-14

160

Large Fab

0.00

160 Large Fab 1 8 14-03-14

Memo 0.00

1-Weld end caps as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/RAluminum Rod 125127

2-Grind end cap welds flush as per Dwg D3562

Ac 14-03-18

170

QC10- Inspect visual per QSI004- ground welds

0.00

170 QC Quality Control ① 14-03-15 DAS 9 9-89

Memo 0.00

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear		General									
Bending		Bend		Folio/Program		Outside Dimensions		Pressure/Forced			
Centre Not Concentric		BOM/Route		Grain		Over/Under tolerance		Set-up			
Cracks		Broken/Damage/Defect		Hardware		Part Incorrect		Temperature/Cure			
Crimp/Kink/Ripple/Wave		Burrs		Inspection Incomplete/Unqualified		Part Lost/Missing		Weld			
Cuffs		Contamination		Instructions Incomplete/Unclear		Part Moved		Wrong Stock Pulled			
Crushing		Countersink		Misaligned/off center		Positioned Wrong					
Heat Treat		Cut Too Short		Mislabeled		Power Loss/Surge		Other			
Inspection Strip in Tube		Drawing		Misread							
Marks/Chatter		Drill Holes		Off-set							
Turning Sequence		Finish		Out of Calibration							
Wave/Twist in Tube		Fit/Function		Out of Sequence							

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Page 4

Item ID: D3562-042

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Step Weldment

Stop

NS2

Start Date: 2/21/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/21/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC5- Inspect part completeness to step on W/O	0.00							DAS
180 QC	Memo	0.00						① 1403-19	9
Quality Control									
190	Chemical Conversion Coat per QSI005 4.1	0.00							
190 HandFinish	Memo	0.00						1 7614320	
Hand Finishing									
200	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
200 Powdercoat	Memo	0.00						1 ♂ 14-3-20	DAS 34 9-89
Powder Coating	START TIME: OVEN TEMPERATURE: FINISH TIME:	8:40 325 9:10							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS							
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General									
	Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced Set-up <input type="checkbox"/>					
	Centre Not Concentric <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>					
	Cracks <input type="checkbox"/>	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Weld <input type="checkbox"/>					
	Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>					
	Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>						
	Crushing <input type="checkbox"/>	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>						
	Heat Treat <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>						
	Inspection Strip in Tube <input type="checkbox"/>	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>							
	Marks/Chatter <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>							
	Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>							
	Wave/Twist in Tube <input type="checkbox"/>	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>							

Work Order ID 113011

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113011

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Item ID: D3562-042

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Step Weldment

Stop

NS2

Start Date: 2/21/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/21/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

210

HandFinish

Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch 1111280900

0.00

1x f LL 14/03/15

220

220

QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

1x 14/03/15DAS
36
9-89

230

230

Packaging

Packaging

Identify as per dwg & Stock Location: 6A

0.00

0.00

1x 14/03/15DAS
36
9-89

DQA: _____ Date: _____

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework Scrap Use-as-is Suspected Unapproved	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											
FAULT CATEGORY											
Landing Gear			General								
Bending	Bend	Folio/Program	Outside Dimensions	Pressure/Forced							
Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Set-up							
Cracks	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure							
Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld							
Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled							
Crushing	Countersink	Misaligned/off center	Positioned Wrong								
Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge								
Inspection Strip in Tube	Drawing	Misread									
Marks/Chatter	Drill Holes	Off-set									
Turning Sequence	Finish	Out of Calibration									
Wave/Twist in Tube	Fit/Function	Out of Sequence									

Work Order ID 113011

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113011

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Item ID: D3562-042

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Step Weldment

Stop

NS2

Start Date: 2/21/14 **Start Qty:** 1.00

1

Cust Item ID:

Required Date: 2/21/14 **Req'd Qty:** 1.00

1

Customer:

Reference:

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	*NR1*
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC21- Final Inspection - Work Order Release	0.00							
240 QC	Memo	0.00							<u>2/14/03-31</u>
Quality Control									<u>D</u> <u>2/14/03-31</u>

DQA: _____

Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

Work Order: _____	DISPOSITION		
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Water Jet <input type="checkbox"/>
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>
		Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>

AGAINST DEPARTMENT/PROCESS

Engineering <input type="checkbox"/>
Quality <input type="checkbox"/>
Other <input type="checkbox"/>

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <table border="1" style="width: 100%; border-collapse: collapse;"> <tr><td>Bend</td><td>Folio/Program</td><td>Outside Dimensions</td><td>Pressure/Forced</td></tr> <tr><td>BOM/Route</td><td>Grain</td><td>Over/Under tolerance</td><td>Set-up</td></tr> <tr><td>Broken/Damage/Defect</td><td>Hardware</td><td>Part Incorrect</td><td>Temperature/Cure</td></tr> <tr><td>Burrs</td><td>Inspection Incomplete/Unqualified</td><td>Part Lost/Missing</td><td>Weld</td></tr> <tr><td>Contamination</td><td>Instructions Incomplete/Unclear</td><td>Part Moved</td><td>Wrong Stock Pulled</td></tr> <tr><td>Countersink</td><td>Misaligned/off center</td><td>Positioned Wrong</td><td></td></tr> <tr><td>Cut Too Short</td><td>Mislabeled</td><td>Power Loss/Surge</td><td>Other</td></tr> <tr><td>Drawing</td><td>Misread</td><td></td><td></td></tr> <tr><td>Drill Holes</td><td>Off-set</td><td></td><td></td></tr> <tr><td>Finish</td><td>Out of Calibration</td><td></td><td></td></tr> <tr><td>Fit/Function</td><td>Out of Sequence</td><td></td><td></td></tr> <tr><td></td><td></td><td></td><td></td></tr> <tr><td></td><td></td><td></td><td></td></tr> <tr><td></td><td></td><td></td><td></td></tr> <tr><td></td><td></td><td></td><td></td></tr> </table>	Bend	Folio/Program	Outside Dimensions	Pressure/Forced	BOM/Route	Grain	Over/Under tolerance	Set-up	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld	Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled	Countersink	Misaligned/off center	Positioned Wrong		Cut Too Short	Mislabeled	Power Loss/Surge	Other	Drawing	Misread			Drill Holes	Off-set			Finish	Out of Calibration			Fit/Function	Out of Sequence																		
Bend	Folio/Program	Outside Dimensions	Pressure/Forced																																																										
BOM/Route	Grain	Over/Under tolerance	Set-up																																																										
Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure																																																										
Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld																																																										
Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled																																																										
Countersink	Misaligned/off center	Positioned Wrong																																																											
Cut Too Short	Mislabeled	Power Loss/Surge	Other																																																										
Drawing	Misread																																																												
Drill Holes	Off-set																																																												
Finish	Out of Calibration																																																												
Fit/Function	Out of Sequence																																																												

Picklist Print

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Work Order ID: 113011

113011
D3562-042

Parent Item: D3562-042

Parent Item Name: Step Weldment

Start Date: 2/21/14

Required Date: 2/21/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-11-09 JLM
IPP rev B ECN 987 07.10.09 EC verified by: DD
IPP Rev:C ECN1048 07-12-18 DD verified by: EC
IPP Rev:D 08-07-28 add chemical conversion coat DD verf:EC IPP REV:E
13.06.03 PER DWG REV.F DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C		Manufactured	No			100	Each	183.0000	1	1			

D2622-120C

Step Extrusion

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
HALL	153	
	105575	41
	109575	112
WA003	30	
	101765	30

D2734

D2734

Step End Plate

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA003	161	
<u>105712</u>	101	
<u>99709</u>	60	

D3560-042

D3560-042

Arm Weldment

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Cod</u>
WA003	3	
108072	2	
108465	1	

DQA:

Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: _____

Work Order update only

Work Order: _____	DISPOSITION		
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Water Jet <input type="checkbox"/>
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>
		Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>

AGAINST DEPARTMENT/PROCESS

Engineering <input type="checkbox"/>
Quality <input type="checkbox"/>
Other <input type="checkbox"/>

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <table border="1"> <tr><td>Bend</td><td>Folio/Program</td><td>Outside Dimensions</td><td>Pressure/Forced</td></tr> <tr><td>BOM/Route</td><td>Grain</td><td>Over/Under tolerance</td><td>Set-up</td></tr> <tr><td>Broken/Damage/Defect</td><td>Hardware</td><td>Part Incorrect</td><td>Temperature/Cure</td></tr> <tr><td>Burrs</td><td>Inspection Incomplete/Unqualified</td><td>Part Lost/Missing</td><td>Weld</td></tr> <tr><td>Contamination</td><td>Instructions Incomplete/Unclear</td><td>Part Moved</td><td>Wrong Stock Pulled</td></tr> <tr><td>Countersink</td><td>Misaligned/off center</td><td>Positioned Wrong</td><td></td></tr> <tr><td>Cut Too Short</td><td>Mislabeled</td><td>Power Loss/Surge</td><td>Other</td></tr> <tr><td>Drawing</td><td>Misread</td><td></td><td></td></tr> <tr><td>Drill Holes</td><td>Off-set</td><td></td><td></td></tr> <tr><td>Finish</td><td>Out of Calibration</td><td></td><td></td></tr> <tr><td>Fit/Function</td><td>Out of Sequence</td><td></td><td></td></tr> <tr><td></td><td></td><td></td><td></td></tr> <tr><td></td><td></td><td></td><td></td></tr> <tr><td></td><td></td><td></td><td></td></tr> <tr><td></td><td></td><td></td><td></td></tr> </table>	Bend	Folio/Program	Outside Dimensions	Pressure/Forced	BOM/Route	Grain	Over/Under tolerance	Set-up	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld	Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled	Countersink	Misaligned/off center	Positioned Wrong		Cut Too Short	Mislabeled	Power Loss/Surge	Other	Drawing	Misread			Drill Holes	Off-set			Finish	Out of Calibration			Fit/Function	Out of Sequence																		
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Finish	Out of Calibration																																																												
Fit/Function	Out of Sequence																																																												

Picklist Print

February-11-14 3:18:42 PM

Page 2

Work Order ID: 113011

113011
D3562-042

Parent Item: D3562-042

Parent Item Name: Step Weldment

Start Date: 2/21/14

Required Date: 2/21/14

Start Qty: 1.00

Required Qty: 1.00

D3560-044

Manufactured

No

140

Each

4.0000

1

1

**

Ar 14-03-11

D3560-044

Arm Weldment

Location

Loc Qty

Loc Code

WA003

4

108137

4

MS20600-AD4W5

Purchased

No

160

Each

286.0000

32

32

**

108137 → (1)

Ar 14-03-13

MS20600-AD4W5

Blind Rivet

Location

Loc Qty

Loc Code

ST311

238

m127376

238

WA003

48

m125654

48

(32)

DQA:

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only

Work Order: _____	DISPOSITION		
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Water Jet <input type="checkbox"/>
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>
		Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>

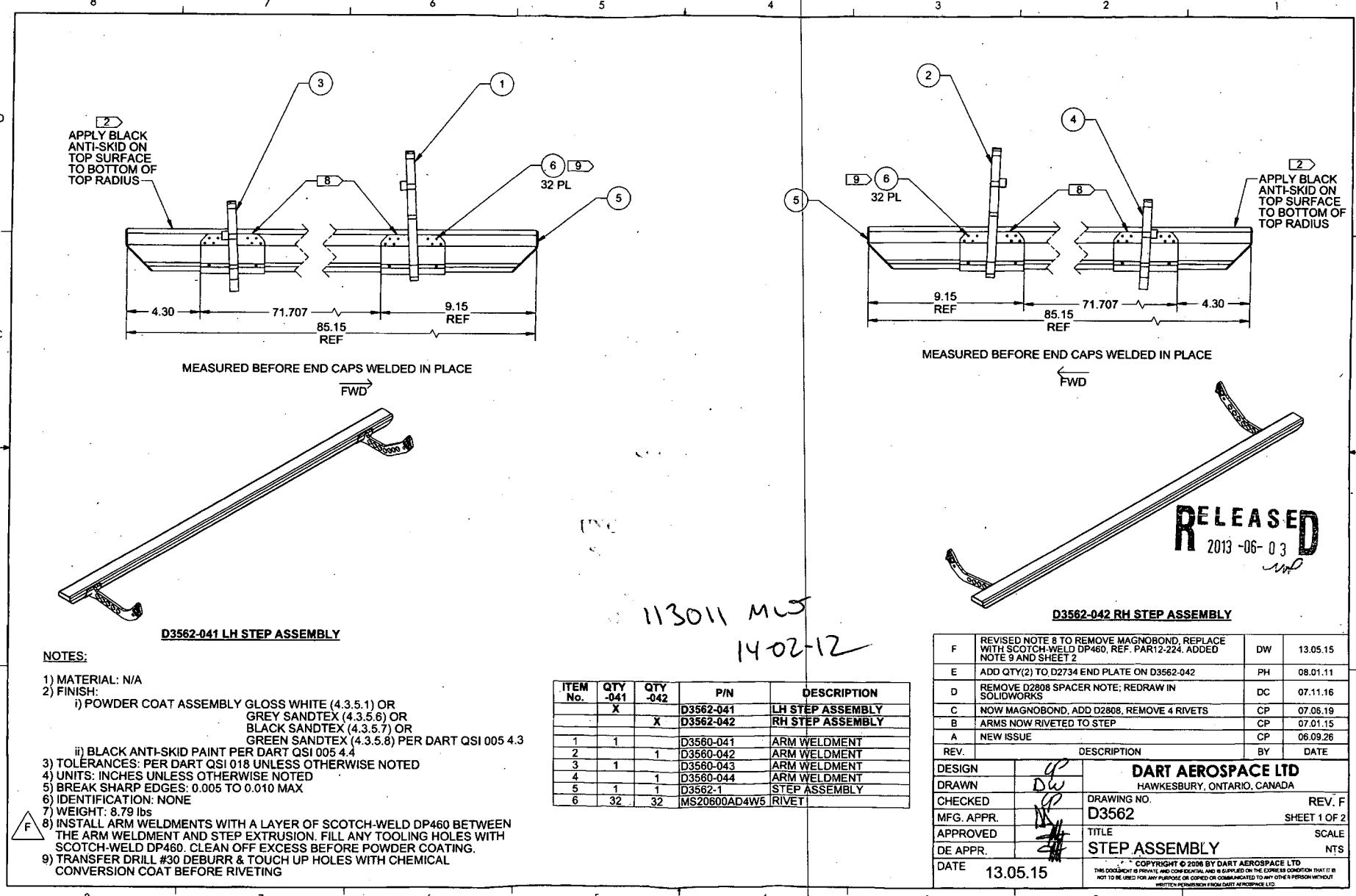
AGAINST DEPARTMENT/PROCESS

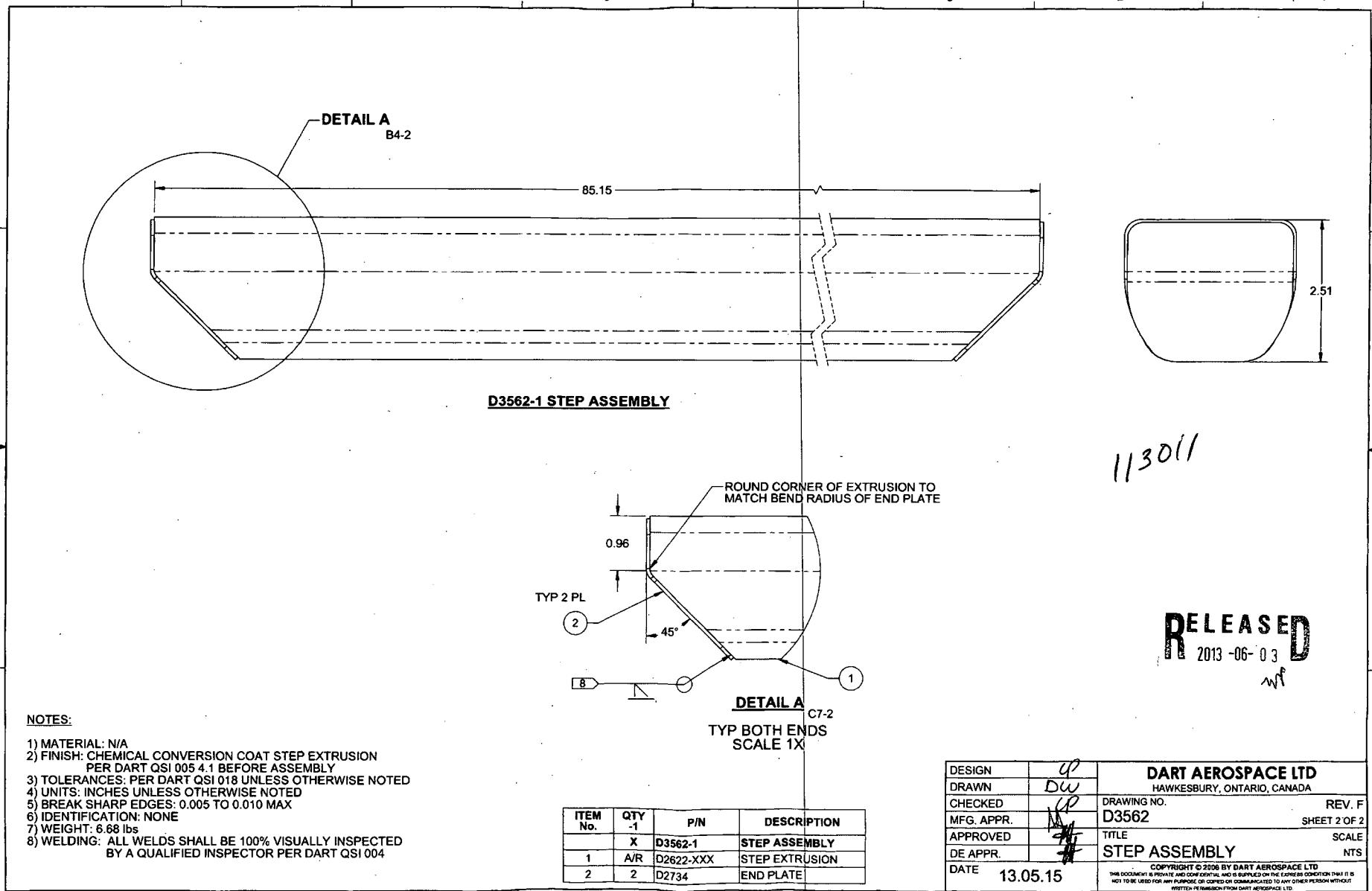
Engineering <input type="checkbox"/>
Quality <input type="checkbox"/>
Other <input type="checkbox"/>

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
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Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear		General									
		<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Pressure/Forced					
		<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Set-up					
		<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Temperature/Cure					
		<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Weld					
		<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Wrong Stock Pulled					
		<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong	<input type="checkbox"/> Other					
		<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge						
		<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread							
		<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set							
		<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration							
		<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence							





DESIGN	40	DART AEROSPACE LTD	
DRAWN	DW	HAWKESBURY, ONTARIO, CANADA	
CHECKED	HP	DRAWING NO. D3562	
MFG. APPR.	NA	REV. F	
APPROVED	#	SHEET 2 OF 2	
DE APPR.	#	TITLE	SCALE
DATE 13.05.15		STEP ASSEMBLY	NTS

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